

Date: Thursday, 01/05/2008 11:57:02 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : AFT DOUBLER

Job Number : 38946

Estimate Number : 13277

P.O. Number :

This Issue : 01/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SMALL / MED FAB

Previous Run : 38841

Part Number : D37033

Drawing Number : D3703 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 05/05/2008

FOR ENGINEERING USE ONLY

Qty: 2 Um: Each

Written By : JLO 08.05.01

Checked & Approved By : JLO 08.05.01

Comment : Est Rev:A 08-04-24 new issue DD verified by:EC

Additional Product

PROTOTYPE

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.7877 sf(s)/Unit Total : 3.9386 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 167387 IB 8-5-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3703

Dwg Rev: PRE L IB 8-5-1

Prog Rev: PRE L

2- Deburr if necessary IB 8-5-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL 08.05.21

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1








Comment: Form as per dwg D3703

IB 08.05.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.15	5-0	PART. PROVED TO BE INADEQUATE FOR INSTALLATION.	 08.05.15	MAKE PART AND REVERSE ENG. ON PART. ATTACH NEW DWG ON W/O.	 BN 107382	 08.05.21	 08.05.15	 08.05.15

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.05.21

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Not required

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08.05.21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.22

Job Completion



Prototype

MF 08-06-13

Dart Aerospace Ltd

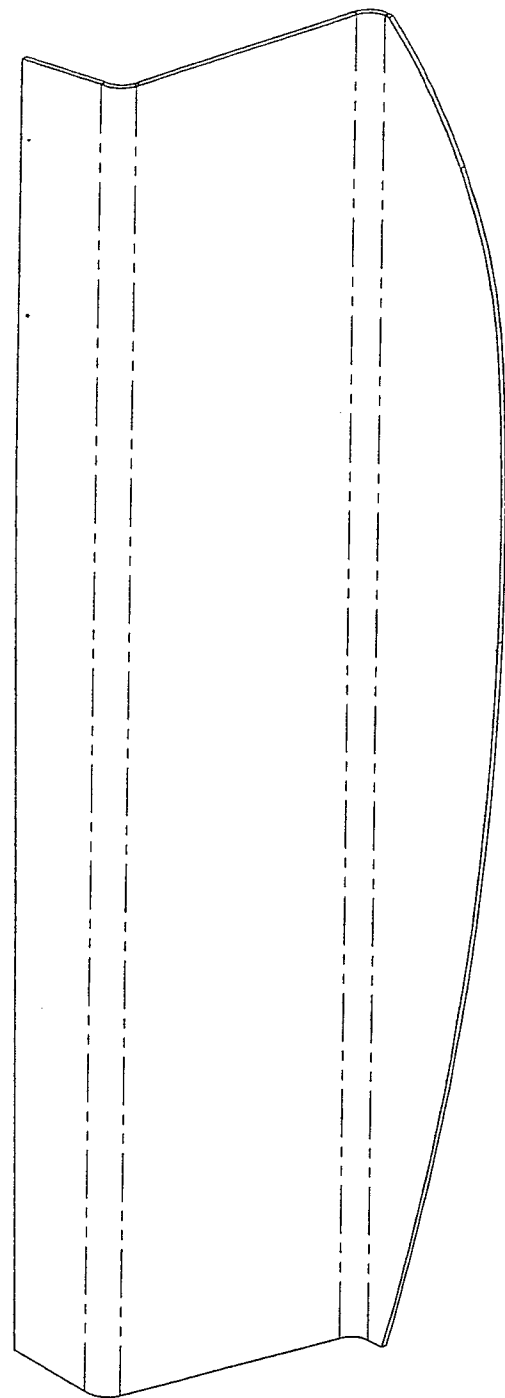
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

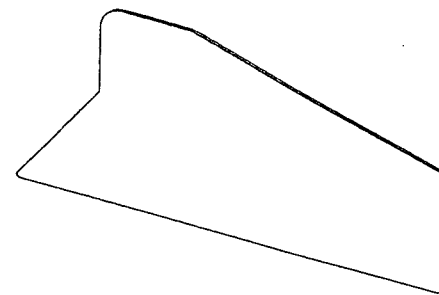
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

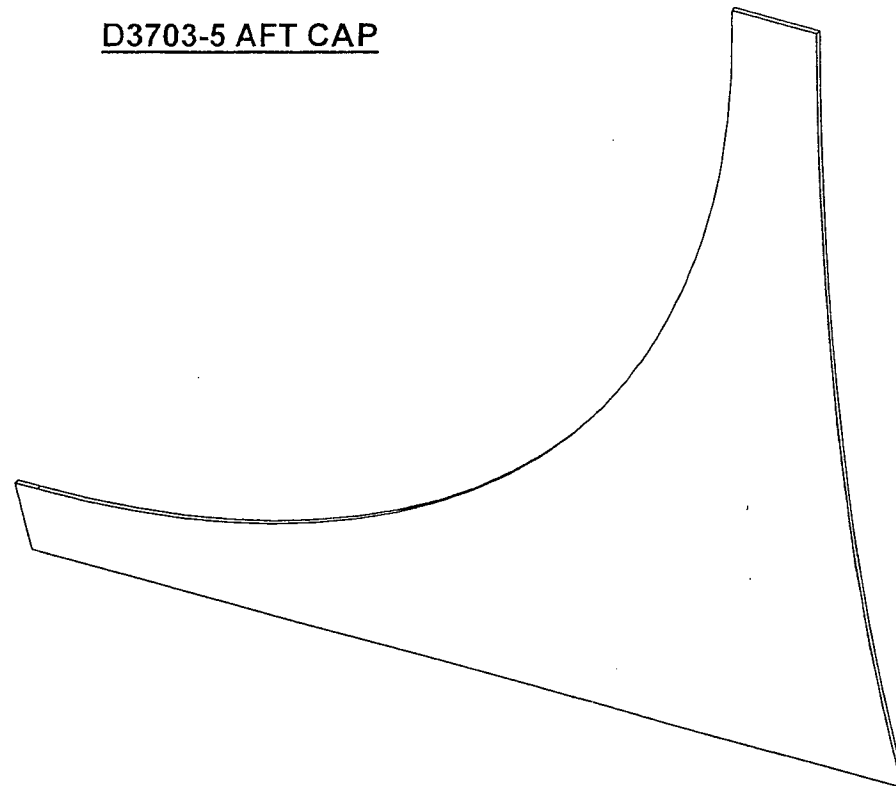
NOTE: Date & initial all entries



D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

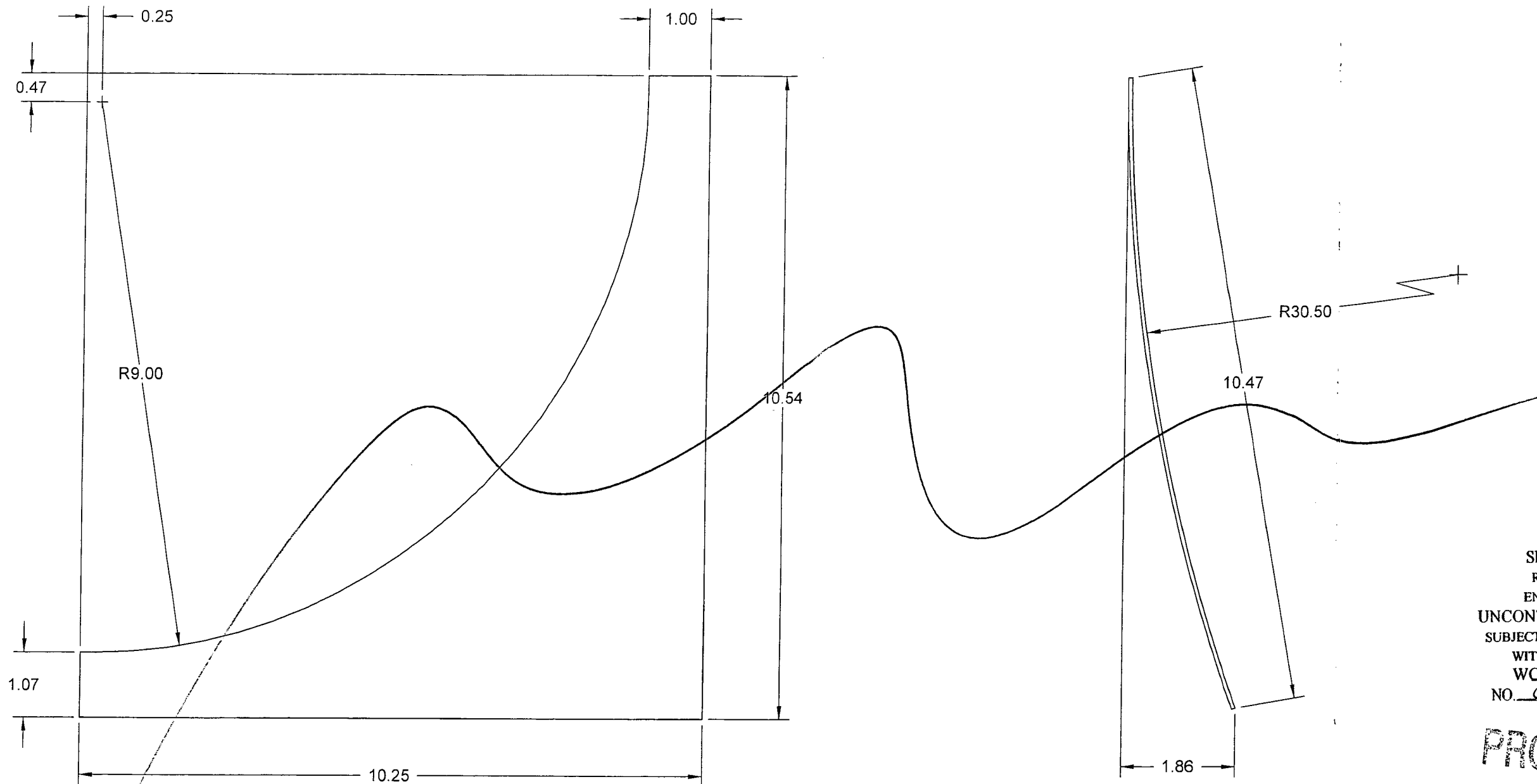
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38946

**PROTOTYPE
PRELIMINARY ISSUE**
08.04.30

A	NEW ISSUE		MB	08.04.30
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3703	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		AFT DOUBLER	NTS	
DATE	08.04.30		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3703-3F AFT CORNER DOUBLER FLAT PATTERN

D3703-3 AFT CORNER DOUBLER
(MAKE FROM D3703-3F)

CHANGE DESIGN
PER ATTACHED DATA
REVERSED ENGINEERED
FROM PART MADE BY
D. STAN. 08.05.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38946

PROTOTYPE

PRELIMINARY ISSUE

08.04.30

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3703	REV. A
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE AFT DOUBLER	SCALE NTS
DE APPR.			
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MAGNA STAINLESS DIV. DE CSM IN
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-

VENDEUR À /
SOLD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

COMMANDE SALES ORDER	CODE DE CLIENT CUSTOMER CODE	BON D'ACHAT DU CUSTOMER PURCHASE
0165970	DART	5851
DELIVER VIA / ENVOIE VIA	CONDITIONS - TERMS	DATE COMMANDE DATE ORDER
NIR:R-557065-1	NET 30	Mar-1

QUALITE		QUALITY	UNITE	N° DE COULEE	DESCRIPTION
COMMANDEE ORDERED	A VENDRE BY	UNIT	HEAT NUMBER		
4pc 8		lbs	F11503CR	304L ROUND 1/4" DIA	
2pc 26		lbs	41043	6061-T6 ALUM 3/4 SQ	
3pc 131		lbs	1628331	USE MTR #CA533	
5pc 443		lbs	426603	6061-T6 .063 X 48 X	
				USE MTR #BZ853	
				6061-T6 AL FLAT 1 1	
				USE MTR #CE459	
TOTAL :					

JOMBRE DE PAQ. / NUMBER OF BOL'S: 1 BOL
 MTR-AVEC COMMANDE / MTR'S-WITH ORDER: ☒
 POSTE / MAIL: ☐ TÉLÉSCOPIEUR / FAX: ☐
 Age: 1 / 156
 08:50:24 20080311 N° DE COULÉE ÉTAMPER SUR LE CÔTÉ / HEAT NO. STAMP ONE END: ☐

MATERIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

receiving reports

Date:

~~8/3/2~~

Batch No

M1.7387

Supplier:

माधव

Dat P/O

5801

Packing Slip:
Invoice:
Receipt:

Yes	<input checked="" type="checkbox"/>	No
Yes	<input type="checkbox"/>	No
Cash	<input type="checkbox"/>	Cr

Release Note Attached
Waybill Attached:
Shipment Complete:
QC6 Inspection _____
Work Order _____

Yes	<input checked="" type="checkbox"/>	No	<input checked="" type="checkbox"/>	N/A	<input type="checkbox"/>
Yes	<input type="checkbox"/>	No	<input checked="" type="checkbox"/>	N/A	<input checked="" type="checkbox"/>
Yes	<input type="checkbox"/>	No	<input checked="" type="checkbox"/>	N/A	<input checked="" type="checkbox"/>
Yes	<input type="checkbox"/>	No	<input checked="" type="checkbox"/>	N/A	<input checked="" type="checkbox"/>

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M20345	Boys	128	0	0	128	
M661763	New Kids	20	0	0	20	

Initials of receiver (if shipment OK)	Level 12

Production/Admin: _____
Date _____

Date _____

Initial

Location

H:\FORMS\purchasing\approved purch\RECREPORT Rev D

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NRBST : 03484/04

PAGE : 1/ 2

INSPECTION CERTIFICATE

Aleris
Europe

CUSTOMER : ALERIS ALUMINUM US SALES INC.

Aleris Aluminum Duffel BVBA
A. Stockman 87, 2570 Duffel - Belgium

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)
OUR ORDER NUMBER : 03484/04
DOCUMENT NUMBER : V/0080236963

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .063"
ARTICLE NO. :

08/12

COIL
NUMBER

CAST
NUMBER

CHEMICAL COMPOSITION (%)

	MIN	SI	FE	CU	MN	MG	CR	TI	ZN
	MAX	0,40		0,15		0,8	0,04		
		0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
004		0,62	0,4	0,19	0,07	1,0	0,15	0,03	0,05
005		0,68	0,4	0,20	0,08	1,0	0,17	0,02	0,03

1628301
1628331

OTHERS : EACH : MIN
TOTAL : MIN

0,05 MAX
0,15 MAX

MECHANICAL PROPERTIES

TEST-NUMBER (T) = TRANSVERSAL (L) = LONGITUDINAL
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /F = FRONT END /O = RANDOM SAMPLING

TEST-NUMBER	MIN	MAX	RM KSI	RP02 KSI	A %
			42	35	10
004	/A		50	42	13
004	/M		49	42	16
004	/V		50	41	13
005	/A		50	41	16
005	/M		50	41	13
005	/V		50	41	18

Aleris Aluminum Duffel BVBA

59993
24/12

Aleris

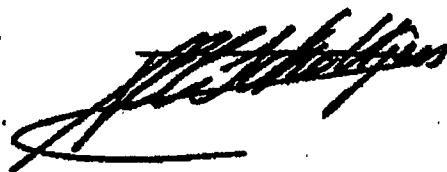
Europe

Aleris Aluminum Duffel BVBA
A. Stockman 67, 2570 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER

004 STENCILLING : WEEK 17 / YEAR 2007
005 STENCILLING : WEEK 17 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS



Aleris Aluminum Duffel BVBA

